

Date: Monday, 08/09/2008 2:51:00 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 41897					
Estimate Number	: 10313					
P.O. Number	:			Part Number	: D26483	
This Issue	: 08/09/2008		S.O. No. :	Drawing Number	: D2648 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: D	
Previous Run	: 41735			Material	:	
Written By	:			Due Date	: 20/09/2008	
Checked & Approved By	: <u>Jul 08.9.08</u>			Qty:	40	Um: Each
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S16GA	1010/1025 sheet 16GA	
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.1500 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: <u>105706</u> FB 8-9-10	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: <u>D</u> FB 8-9-10 Prog Rev: <u>D</u>	44
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	FB 8-9-11
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	S 08/09/11 x44 counter
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary	Done at step 42-2 S 08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 41897		Part Number: D26483
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC 	NC BRAKE 
<b>Comment:</b> NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3		SB 97/09/16 (44)
7.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R560Hardcoat <u>M107553</u> 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary		EL 8-9-23 (44)
8.0	QC10 	VISUAL INSPECTION OF GROUND WELDS  counted
<b>Comment:</b> VISUAL INSPECTION OF GROUND WELDS		S 08/08/03 (44)
9.0	QC5 	INSPECT WORK TO CURRENT STEP 
<b>Comment:</b> INSPECT WORK TO CURRENT STEP		S 08/08/03 (44)
10.0	POWDER COATING 	POWDER COATING <u>M106442</u>  44X
<b>Comment:</b> POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: <u>11:50</u> OVEN TEMPERATURE: <u>320</u> °F FINISH TIME: <u>12:20</u>		<u>m-1</u> 08/09/04
11.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <u>50</u>  44X
<b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION		8/9/04
12.0	PACKAGING 1 	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>FP-17</u>		<u>44</u> <u>08-09-04</u> <u>44X</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 41897

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/24 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 08/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41897
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648	Rev: D	Page 1 of 1

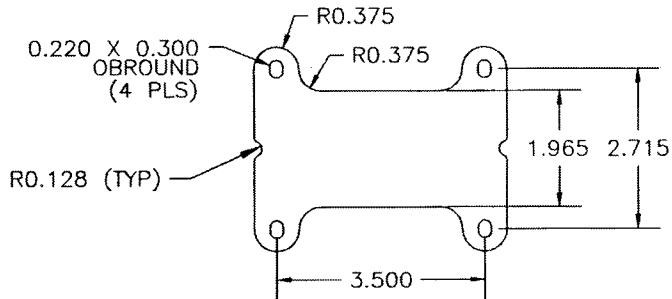
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

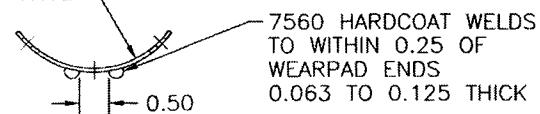
Measured by:	PB	Audited by:	E	Prototype Approval:	N/A
Date:	8-9-11	Date:	8/9/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM	✓

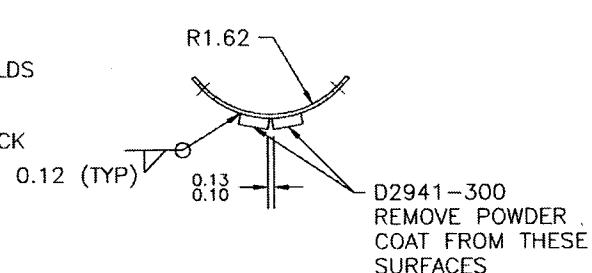
D2648-1 FLAT PATTERN



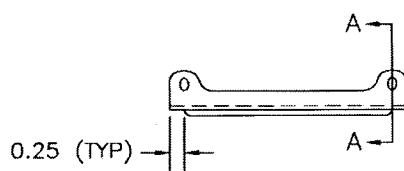
SECTION A-A



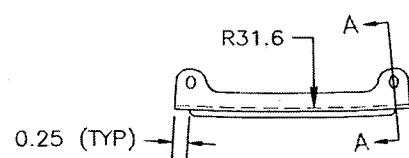
SECTION B-B



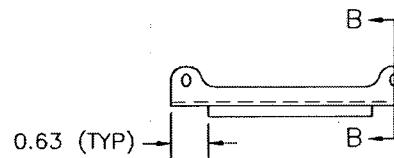
D2648-3 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND  
(MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. D D2648
DATE	TITLE	SCALE 99.11.17 WEARPAD 1:2

RELEASED  
11.12.20 DS

COPY  
03

NO. WPS 898  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
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